

BLUE

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:13:32 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32377
Estimate Number : 10831
P.O. Number : *N/A*
This Issue : 5/16/2007 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : MACHINED PARTS
Previous Run : 32021
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est: B 06.06.26 New DWG rev, (mpp 2069) EC
Est Rev: C As per Rev C 07-03-19 JLM

Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Part Number : D29321
Drawing Number : D2932 REV C
Project Number : N/A
Drawing Revision : C
Material : *N/A*
Due Date : 6/6/2007 Qty: *8* Unit: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : *8* 10.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No: *B 25347*

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr & TUMBLE

3.0 MILLING CONV CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

Date: Wednesday, 5/16/2007 8:13:32 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 32377

Part Number: D29321

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07/06/09

8

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

11

07-06-11

8

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

Atcher Debossel 24p

PO 4034

07-06-25

1

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

07-06-22 11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07-06-25 11

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-06-25

1

Job Completion



07-06-25

| | | |
|---|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 32377 |
| Description: 206 Saddle, Outboard, Left side | | Part Number: D2932-1 |
| Inspection Dwg: D2932 Rev. C | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.100 | 0.140 | | 0.115" | .107 | .108 | .108 | | |
| B | 0.100 | 0.140 | | 0.115" | .107 | .107 | .107 | | |
| C | 0.100 | 0.140 | | 0.117" | .116 | .115 | .117 | | |
| D | 0.210 | 0.230 | | 0.222" | .219 | .220 | .220 | | |
| E | 1.245 | 1.255 | | 1.251" | 1.250 | 1.250 | 1.250 | | |
| F | 1.245 | 1.255 | | 1.250" | 1.250 | 1.250 | 1.250 | | |
| G | 2.495 | 2.505 | | 2.501" | 2.500 | 2.500 | 2.499 | | |
| H | 0.510 | 0.515 | | 0.511" | 0.511 | 0.511 | 0.511 | | |
| I | 1.572 | 1.582 | | 1.579" | 1.577 | 1.577 | 1.577 | | |
| J | 2.495 | 2.505 | | 2.501" | 2.500 | 2.500 | 2.500 | | |
| K | 0.257 | 0.262 | | 0.258" | .259 | .259 | .259 | | |
| L | 0.312 | 0.317 | | 0.313" | .315 | .315 | .315 | | |
| M | 0.235 | 0.240 | | 0.239" | 0.239 | 0.239 | 0.239 | | |
| N | 0.100 | 0.140 | | .114" | .117 | .119 | .117 | | |
| O | 0.540 | 0.560 | | .547" | .550 | .550 | .550 | | |
| P | 0.490 | 0.510 | | .500" | .499 | .500 | .499 | | |
| Q | 3.715 | 3.725 | | 3.722" | 3.719 | 3.719 | 3.718 | | |
| R | 2.470 | 2.510 | | 2.495" | 2.495 | 2.495 | 2.495 | | |
| S | 0.240 | 0.270 | | 0.250" | .243 | .242 | .246 | | |
| T | 0.100 | 0.180 | | 0.135" | .140 | .140 | .140 | | |
| U | 1.625 | 1.635 | | 1.632" | 1.630 | 1.629 | 1.630 | | |
| V | 1.362 | 1.372 | | 1.368" | 1.367 | 1.366 | 1.367 | | |
| W | 0.316 | 0.321 | | 0.319" | .320 | .320 | .320 | | |
| X | 1.125 | 1.145 | | 1.135" | 1.137" | 1.140" | 1.136 | | |
| Y | 1.565 | 1.585 | | 1.575" | 1.576" | 1.580" | 1.573 | | |
| Z | 0.178 | 0.198 | | 0.188" | .188 | .188 | .188 | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

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|-------------------|-------------------------|
| Measured by: J.F. | Audited by: [Signature] |
| Date: 07/05/20 | Date: 07/06/09 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|-------------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |
| C | 07.03.21 | Revised per drawing revision C | KJ/JLM | [Signature] |

| | | | |
|---|--|---------------------|----------------|
| DART AEROSPACE LTD | | Work Order: | 32377 |
| Description: 206 Saddle, Outboard, Left side | | Part Number: | D2932-1 |
| Inspection Dwg: D2932 Rev. C | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.100 | 0.140 | | .110 | .109 | .109 | .113 | | |
| B | 0.100 | 0.140 | | .110 | .107 | .107 | .112 | | |
| C | 0.100 | 0.140 | | .117 | .117 | .115 | .120 | | |
| D | 0.210 | 0.230 | | .219 | .220 | .220 | .221 | | |
| E | 1.245 | 1.255 | | 1.249 | 1.250 | 1.250 | 1.250 | | |
| F | 1.245 | 1.255 | | 1.249 | 1.250 | 1.250 | 1.250 | | |
| G | 2.495 | 2.505 | | 2.500 | 2.499 | 2.500 | 2.500 | | |
| H | 0.510 | 0.515 | | 0.511 | 0.511 | 0.511 | 0.511 | | |
| I | 1.572 | 1.582 | | 1.577 | 1.577 | 1.577 | 1.577 | | |
| J | 2.495 | 2.505 | | 2.500 | 2.500 | 2.499 | 2.500 | | |
| K | 0.257 | 0.262 | | .257 | .257 | .259 | .259 | | |
| L | 0.312 | 0.317 | | .315 | .315 | .315 | .315 | | |
| M | 0.235 | 0.240 | | 0.239 | 0.239 | 0.239 | 0.239 | | |
| N | 0.100 | 0.140 | | .116 | .116 | .118 | .117 | | |
| O | 0.540 | 0.560 | | .549 | .550 | .550 | .549 | | |
| P | 0.490 | 0.510 | | .499 | .500 | .501 | .500 | | |
| Q | 3.715 | 3.725 | | 3.719 | 3.719 | 3.719 | 3.719 | | |
| R | 2.470 | 2.510 | | 2.495 | 2.495 | 2.495 | 2.495 | | |
| S | 0.240 | 0.270 | | .248 | .246 | .247 | .249 | | |
| T | 0.100 | 0.180 | | .140 | .140 | .140 | .140 | | |
| U | 1.625 | 1.635 | | 1.630 | 1.630 | 1.630 | 1.630 | | |
| V | 1.362 | 1.372 | | 1.367 | 1.367 | 1.367 | 1.367 | | |
| W | 0.316 | 0.321 | | .320 | .320 | .320 | .320 | | |
| X | 1.125 | 1.145 | | 1.133 | 1.135 | 1.137 | 1.134 | | |
| Y | 1.565 | 1.585 | | 1.571 | 1.572 | 1.574 | 1.570 | | |
| Z | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

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|--------------|----------------------------|
| Measured by: | SL |
| Date: | 07/05/22 / 07/06/07 |

| | |
|-------------|-----------------|
| Audited by: | Em |
| Date: | 07/06/09 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |
| C | 07.03.21 | Revised per drawing revision C | KJ/JLM | |

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|---|--|---------------------|----------------|
| DART AEROSPACE LTD | | Work Order: | 32377 |
| Description: 206 Saddle, Outboard, Left side | | Part Number: | D2932-1 |
| Inspection Dwg: D2932 Rev. C | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|---|---|---|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.100 | 0.140 | | | | | | | |
| B | 0.100 | 0.140 | | | | | | | |
| C | 0.100 | 0.140 | | | | | | | |
| D | 0.210 | 0.230 | | | | | | | |
| E | 1.245 | 1.255 | | | | | | | |
| F | 1.245 | 1.255 | | | | | | | |
| G | 2.495 | 2.505 | | | | | | | |
| H | 0.510 | 0.515 | | | | | | | |
| I | 1.572 | 1.582 | | | | | | | |
| J | 2.495 | 2.505 | | | | | | | |
| K | 0.257 | 0.262 | | | | | | | |
| L | 0.312 | 0.317 | | | | | | | |
| M | 0.235 | 0.240 | | | | | | | |
| N | 0.100 | 0.140 | | | | | | | |
| O | 0.540 | 0.560 | | | | | | | |
| P | 0.490 | 0.510 | | | | | | | |
| Q | 3.715 | 3.725 | | | | | | | |
| R | 2.470 | 2.510 | | | | | | | |
| S | 0.240 | 0.270 | | | | | | | |
| T | 0.100 | 0.180 | | | | | | | |
| U | 1.625 | 1.635 | | | | | | | |
| V | 1.362 | 1.372 | | | | | | | |
| W | 0.316 | 0.321 | | | | | | | |
| X | 1.125 | 1.145 | | | | | | | |
| Y | 1.565 | 1.585 | | | | | | | |
| Z | 0.178 | 0.198 | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|--|
| Measured by: | |
| Date: | |

| | |
|-------------|--|
| Audited by: | |
| Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |
| C | 07.03.21 | Revised per drawing revision C | KJ/JLM | |

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|---|-----------------------------|
| DART AEROSPACE LTD | Work Order: 32377 |
| Description: 206 Saddle, Outboard, Left side | Part Number: D2932-1 |
| Inspection Dwg: D2932 Rev. C | Page 1 of 1 |

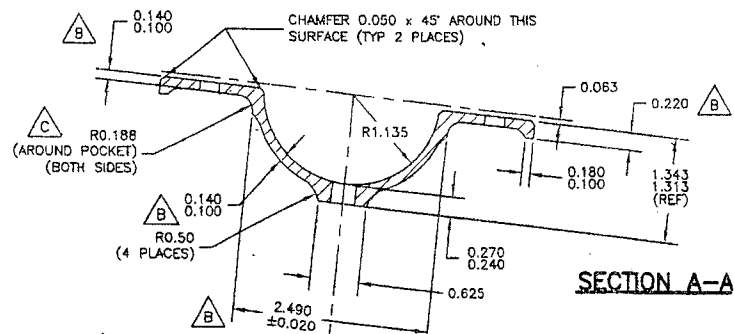
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|---|---|---|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.100 | 0.140 | | | | | | | |
| B | 0.100 | 0.140 | | | | | | | |
| C | 0.100 | 0.140 | | | | | | | |
| D | 0.210 | 0.230 | | | | | | | |
| E | 1.245 | 1.255 | | | | | | | |
| F | 1.245 | 1.255 | | | | | | | |
| G | 2.495 | 2.505 | | | | | | | |
| H | 0.510 | 0.515 | | | | | | | |
| I | 1.572 | 1.582 | | | | | | | |
| J | 2.495 | 2.505 | | | | | | | |
| K | 0.257 | 0.262 | | | | | | | |
| L | 0.312 | 0.317 | | | | | | | |
| M | 0.235 | 0.240 | | | | | | | |
| N | 0.100 | 0.140 | | | | | | | |
| O | 0.540 | 0.560 | | | | | | | |
| P | 0.490 | 0.510 | | | | | | | |
| Q | 3.715 | 3.725 | | | | | | | |
| R | 2.470 | 2.510 | | | | | | | |
| S | 0.240 | 0.270 | | | | | | | |
| T | 0.100 | 0.180 | | | | | | | |
| U | 1.625 | 1.635 | | | | | | | |
| V | 1.362 | 1.372 | | | | | | | |
| W | 0.316 | 0.321 | | | | | | | |
| X | 1.125 | 1.145 | | | | | | | |
| Y | 1.565 | 1.585 | | | | | | | |
| Z | 0.178 | 0.198 | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

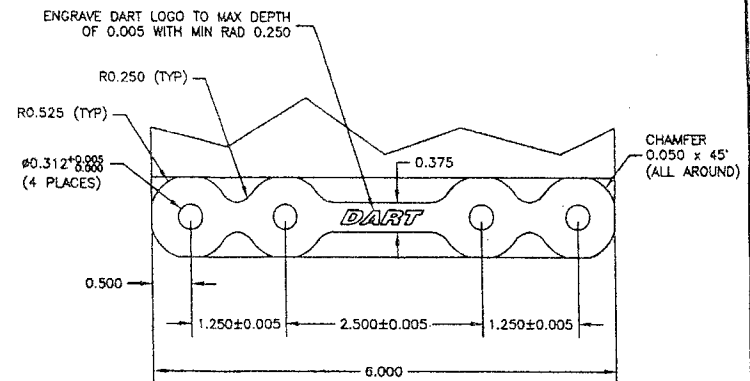
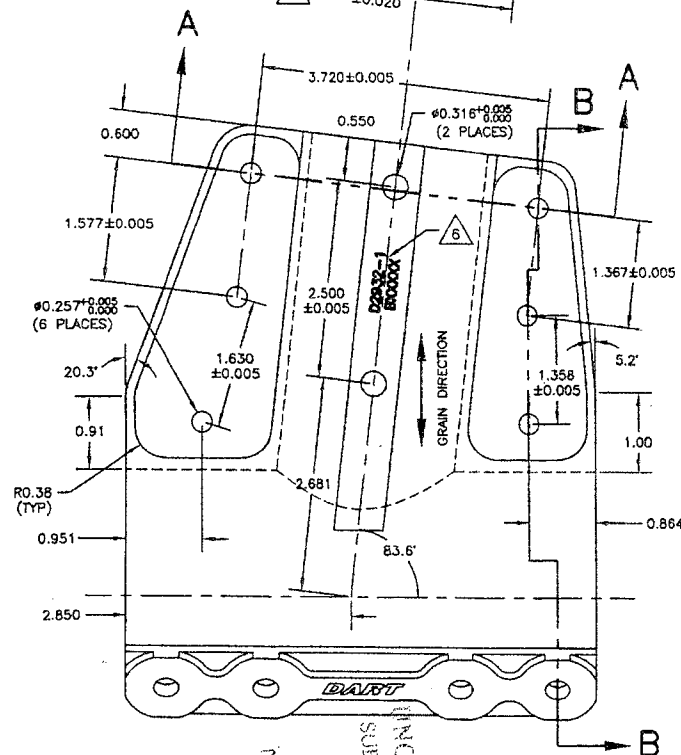
| | |
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| Measured by: | |
| Date: | |

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| Audited by: | |
| Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |
| C | 07.03.21 | Revised per drawing revision C | KJ/JLM | |

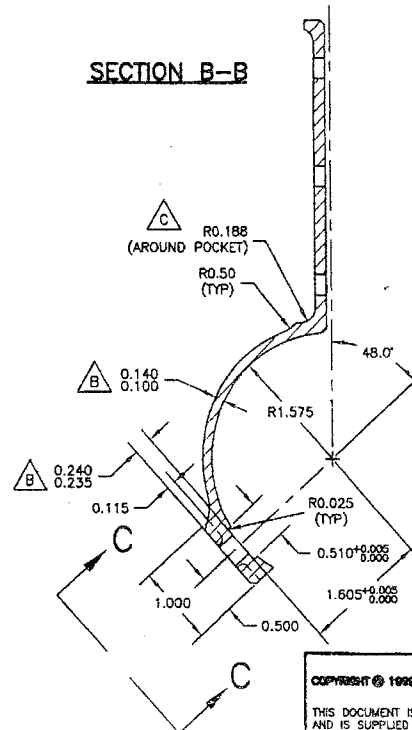


SECTION A-A



VIEW C-C

SECTION B-B



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (20-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

| | | |
|----------|----------------|---|
| C | 06.11.09 | RD.188 WAS RD.30 TO RD.25 |
| B | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A | 99.10.29 | NEW ISSUE |
| DESIGN | DRAWN BY | DART DART AEROSPACE USA, INC. BELLINGHAM, WA |
| CHECKED | APPROVED | DRAWING NO. D2932 |
| DATE | TITLE | SCALE |
| 06.11.09 | SADDLE OUTSIDE | 2:3 |

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DART AEROSPACE USA, INC.

RELEASED
07-02-12

NO. 32377
WORK ORDER
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IN CONTROLLED
RETURN TO
SHOP COPY
ENGINEERING
SUBJECT TO AVAL
WITHOUT NOTI
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